

# Work Order ID 86189

\*86189\*

Page 1

June-22-12 2:27:06 PM

Item ID: D119-756-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Clamp

Stop \*NS2\*

Start Date: 22/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/22* Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

N/A

Rev C

100

0.00

*DAS 15 12/06/30*

\*100\*

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile & type labels per PPPD119-756-011

CHG001

*JB*

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

*12/08/29 JB*

*82*

120

QC4- 100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control

*DAS 3 12/06/30*

*(Signature)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Revision ID:

Item Name: Clamp

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-756-011								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

POD 84508

12/13/08

12/19/11

12-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

June-22-12 2:27:10 PM

Page 1

Work Order ID: 86189

\*86189\*

Parent Item: D119-756-011

\*D119-756-011\*

Parent Item Name: Clamp

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-06-27 JLM  
IPP rev B Rev B dwg, picklist 06.07.26 EC  
IPP rev C rec C dwg no picklist chg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2617-3		Manufactured	No			110	Each	28.0000	2	2			
*D2617-3*									**	86394 JB			
Bushing													

Location	Loc Qty	Loc Code
FG	10	
27991	10	
ST012	18	
76948	6	
84008	12	

D2617-5		Manufactured	No			110	Each	36.0000	4	4			
*D2617-5*									**	86395 JB			
Spacer													

Location	Loc Qty	Loc Code
FG	10	
31756	10	
ST012	26	
81814	10	
85423	16	

D2732		Manufactured	No			110	f	526.0000	1.0666	1.122737			
*D2732*									**				
Rubber Extrusion													

Location	Loc Qty	Loc Code
ST410	526	
70987	30	
83560	496	

1- cut 4 pieces at 3.20" as per dwg (D2732-032)

JB 12/08/29

83560

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-22-12 2:27:10 PM

Page 2

Work Order ID: 86189

Parent Item: D119-756-011

Parent Item Name: Clamp

\*86189\*

\*D119-756-011\*

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3789-1 Manufactured No

110 Each 8.0000

\*D3789-1\*  
Clamp

1 1 ✓  
\*\* JB

Location

Loc Qty

Loc Code

ST462

8

72547

8

72547

D3789-3 Manufactured No

110 Each 0.0000

\*D3789-3\*  
Clamp

1 1 ✓  
\*\* JB

D3789-5 Manufactured No

110 Each 19.0000

\*D3789-5\*  
Clamp

1 1 ✓  
\*\* JB

Location

Loc Qty

Loc Code

ST462

19

77774

19

77774

D3789-7 Manufactured No

110 Each 0.0000

\*D3789-7\*  
Clamp

1 1 ✓  
\*\* JB

AN960JD416 NAS1149D0463J Purchased No

110 Each 31.0000

\*AN960JD416\*  
Washer

4 4 ✓  
\*\* JB

Location

Loc Qty

Loc Code

ST351

31

116289

10

119097

21

12244 JB 12/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-22-12 2:27:10 PM

Page 3

Work Order ID: 86189

Parent Item: D119-756-011

Parent Item Name: Clamp

\*86189\*

\*D119-756-011\*

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

2.558.000

\*MS21042L4\*

Nut

\*\*

122452 JB

Location

Loc Qty

Loc Code

ST300

2558

119075

116

121011

193

121444

1949

121652

300

AN4-24A

Purchased

No

110

Each

50.0000

\*AN4-24A\*

Bolt

\*\*

JB

Location

Loc Qty

Loc Code

ST359

50

117514

50

AN4-22A

Purchased

No

110

Each

167.0000

\*AN4-22A\*

Bolt

\*\*

122416 JB 12/08/29

Location

Loc Qty

Loc Code

ST359

167

116419

49

118628

68

120930

50

June-22-12 2:27:10 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 7.0 PARTS LIST

Qty -041	Qty -011	Qty -013	Qty -015	Part Number	Description
X				D119-756-041	HELI-UTILITY-BASKET™
1	X			D119-756-011	CLAMP KIT
		X		D119-756-013	QUICK RELEASE KIT
			X	D119-756-015	CARGO RESTRAINT KIT
2				D2022-101	* SPACER
1				D2258-146	PLACARD (AW119MKII)
1				D2258-154	PLACARD (EASA AIRCRAFT ONLY)
1				D2258-176	PLACARD (A119)
1				D2332-041	* PROP ASSEMBLY
1				D2530	* HANDLE ASSEMBLY
2				D2535	* SPRING
2				D2537	* BUSHING
2	2			D2617-3	BUSHING
4	4			D2617-5	BUSHING
	4			D2732-032	RUBBER CUSHION
2				D2931	* BUMPER
	1			D3789-1	CLAMP
	1			D3789-3	CLAMP
	1			D3789-5	CLAMP
	1			D3789-7	CLAMP
1				D3515-041	* BASKET LID ASSEMBLY
1				D3516-041	* BASKET BASE ASSEMBLY
2				D3516-11	CLEVIS
2				D3517-1	STRUT
2				D3519-1	* PLACARD
1				D3519-3	PLACARD (EASA AIRCRAFT ONLY)
2				D3518-041	STRUT ASSEMBLY
2				D3520-1	SPACER
2				D3520-3	SPACER
2				D3757-1	BLANKING PLATE
			3	D4295-041	STRAP ASSEMBLY

\* indicates that part is pre-assembled on basket for customer

# REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D119-756

Page 16 of 16

Qty -041	Qty -011	Qty -013	Qty -015	Part Number	Description
X				D119-756-041	HELI-UTILITY-BASKET™
1	X			D119-756-011	CLAMP KIT
		X		D119-756-013	QUICK RELEASE KIT
			X	D119-756-015	CARGO RESTRAINT KIT
6				AN3-10A	* BOLT
2				AN3-16A	* BOLT
2				AN4-7A	* BOLT
2				AN4-13A	BOLT
6				AN4-15A	BOLT
2				AN4-20A	BOLT
1	/ 2			AN4-22A	* BOLT
1	/ 2			AN4-24A	* BOLT
2				AN5-10A	BOLT
4				AN5-17A	* BOLT
2				AN960JD416	* WASHER
40	/ 4			AN960JD416	WASHER
2				AN960JD416L	* WASHER
4				AN960JD416L	WASHER
4				AN960JD516	* WASHER
2				AN960JD516L	WASHER
2				AN960JD8	* WASHER
12				AN960JD10	* WASHER
4				AN970-4	* WASHER
		4		BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2				MS20600AD4W3	* RIVET
8				MS21042L3	* NUT (OR MS21042-3)
4				MS21042L4	* NUT (OR MS21042-4)
10	/ 4			MS21042L4	NUT (OR MS21042-4)
4				MS21042L5	* NUT (OR MS21042-5)

\* indicates that part is pre-assembled on basket for customer

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Revision: F

Date: 11.02.16